. ^

Work Ord Friday, May 28												Page 1
Item ID: Revision ID:	D3953-19			Accept					Setup	Start		
Item Name:	Gas Spring Br	racket	1/80131 11010 1101	ı.						Stop		
Start Date: Required Date	5/27/2010 : 6/4/2010	Start Qty: 12.00 Req'd Qty: 12.00]		Cust Item 1 Customer:	D:						
Reference:												
Approvals:	Process Pla	in: <i>[h]</i>	Date (0 5-28	Tooling:	Da	ate:			Run	Start		
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re		Reject Number	Insp. · Stamp
Draw Nbr	Rev	ision Nbr		-								
D3953	C											
				0.00				ιD	10-	£ ~1		
Waterjet FLOW CNC Waterj من المنطقة		Memo 1-Cut as per Dwg Rev: Prog Rev:		0.00				15 A	<u>.</u> 0_ <u>.</u>			~
		2-Deburr if n	,				9	5	0/0] [o]	((5)
110 		QC2- Inspect parts off ma	achine FAI/FAIB	0.00				173	(O- (1-6		

Quality Control

Dart Aerospace L	D	art	Aer	os	pace	Ltd
------------------	---	-----	-----	----	------	-----

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	-											
-												
		PAR #:	Fault Cat	egory:	NO	CR: Yes	No DQ	A:	Date:			
	Res	solution:	Disposition	on:	Q/	A: N/C CIG	osed:		Date:			
NCR:			WORK ORE	DER NON-CONF	ORMANC	E (NCR)					
DATE	STEP Description of NC		Corrective Action Section			Verificatio			Approval	Approval		
		Section A	Initial Chief Eng	Action Descr Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector		
								• •				
MIZTE - C	ata P initial	oll ombring										

Work Order	ID	5921	3
Friday, May 28, 201	10 9:	23:08 A	M



Page 2

Item ID:

D3953-19

Accept

Setup Start

Stop



Revision ID:

Item Name: Gas Spring Bracket

Start Date: 5/27/2010 Required Date: 6/4/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ **Work Center ID**

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

0.00 0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

130

Small Fab

Small Fab

Memo

1- CHAMFER HOLE AS PER DWG

0.00

0.00

2- DEBURR IF NECESSARY

QC5- Inspect part completeness to step on W/O

140

Quality Control

Memo

0.00

Dari Aerospace	art Aerospa	ice Ltd
----------------	-------------	---------

W/0: 59213		WORK ORDER CHA	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
idd1	# 120	Took aly &1 For QC inspection template	8	rolobla	41		10/06/09			
		,		·						

Part No: <u>₱ 3953 - 19</u> PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Verification	Annroyal	A					
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	iption Sign & Date		Chief Eng	Approval QC Inspector			
			*.							
			:			·				
	ž.									
			,							
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section A Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng			

Work Order ID 59213

Friday, May 28, 2010 9:23:08 AM



Page 3

Item ID:

D3953-19

Accept

Setup Start



Revision ID:

Item Name: Gas Spring Bracket

Start Date:

Required Date: 6/4/2010

5/27/2010

Start Oty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

A	pprovals:	
	FF-0.44.01	

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:_____

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Stop



Sequence ID/ **Work Center ID**

150

Packaging

Operation Description

Identify as per dwg & Stock Location: 10' 7

Memo

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

10.6.2

Reject **Qty**

Reject Insp. Number

Stamp

Packaging

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/06/039

U 10.06.03

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE				te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				;							
									The state of the s		
Part No	<u> </u>	PAR #:	Fault Cate	egory:	NCR: Ye	s No	DOA:	Date			
		esolution:									
NCR:	-	,	WORK ORD	ER NON-CONFORM	ANCE (N	CR)					
DATE	CTED	Description of NC	Corrective Action Section B			V ₁	erification	Approval	Approval		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n &	Section C	Chief Eng	QC Inspector		
II.											
							·				
				,							
				ţ							
,											

'Picklist Print

Friday, May 28, 2010 9:23:12 AM

Work Order ID: 59213

Parent Item: D3953-19

Parent Item Name: Gas Spring Bracket

Comments:

dwg revC DD 10.03.02 verified by:EC

IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per **Start Date:** 5/27/2010

Required Date: 6/4/2010 **Start Qty: 12.00**

Required Qty: 12.00

Page 1

Status

Component Item ID/ Item Name

M304S11GA

Replacement Mfg/ Item ID

Purch Purchased

Bin **Primary** Item Location No

Last Location Route Seq ID 100

Unit of Qty on Measure Hand sf 35.9300 Qty per Kit 0.018

Total Qty Otv 0.227368

Issued Issued .27

B10-6-

Date

304/316 0.125 Sheet

Location

MAT

114488

Loc Qty

35.93 35.93 Loc Code

114488



W/O:			WO	RK ORDER CHANG	GES					1:
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							····			
Part No	:	PAR #:	Fault Categ	jory:	NCR:	Yes I	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	:	QA: N/C Closed: Date:					
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verificati			Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
				·						

DART AEROSPACE LTD	Work Order:	59213
Description: Gas Spring Bracket	Part Number:	D3953-19
Inspection Dwg: D3953 Rev: C		Page 1 of 1
FIRST ARTICLE INS X First Articl	SPECTION CHECKLIST e Prototype	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	.196	4			
Ø0.257	+0.006/-0.001	196.	*			
0.38	+/-0.030	(38)	7			
1.38	+/-0.030	1.385	84			
0.625	+/-0.010	<i>.</i> 692	¥			
0.375	+/-0.010	.371	¥			
1.00	+/-0.030	1.005	₩			
1.686	+/-0.010		Z D345	5 ir		
2.06	+/-0.030		5	- 1. j		
0.125	+/-0.010	.119	8			

Measured by: R	Audited by:	Prototype Approval:	N/A
Date: 10-6-1	Date: 0 06 0	Date:	N/A

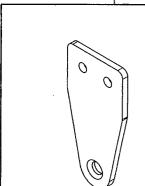
Rev	Date	Change	Revised by	Approved
Α	10.03.31	New Issue	KJ KJ	
				7~1

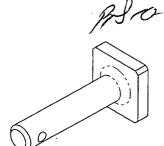
W/O:			WC	ORK ORDER CHANG	ES			1
DATE	STEP	PROCEDURE CHANGE				Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-					
		PAR #:	Fault Cate	gory:	_ NCR: Yes	Date: _		
	Resolution:		Disposition	າ:	_ QA: N/C Cld	sed:	Date:	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR)	Also	
DATE	STEP	Description of NC	ion of NC Corrective Action			Verification	cation Approval	Approval
	-	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								1
···								
	1 1				1	1	1	1

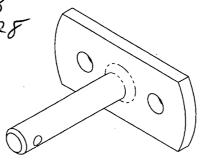
SHOP COPY RETURN TO **ENGINEERING** UNCONTROLL BD COPY

SUBJECT TO AMENDMENT 6 WITHOUT NOTICE 5

WORK URDER











D3953-1 GAS SPRING BRACKET (FULL LID)

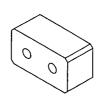
D3953-3 GAS SPRING STUD, LID

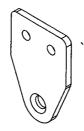
D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER











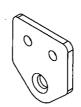
D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER (FULL LID)

D3953-15 GAS SPRING BRACKET (SPLIT LID)

D3953-17 GAS SPRING SPACER (SPLIT LID)

D3953-19 GAS SPRING BRACKET (SQUARE BASKET)



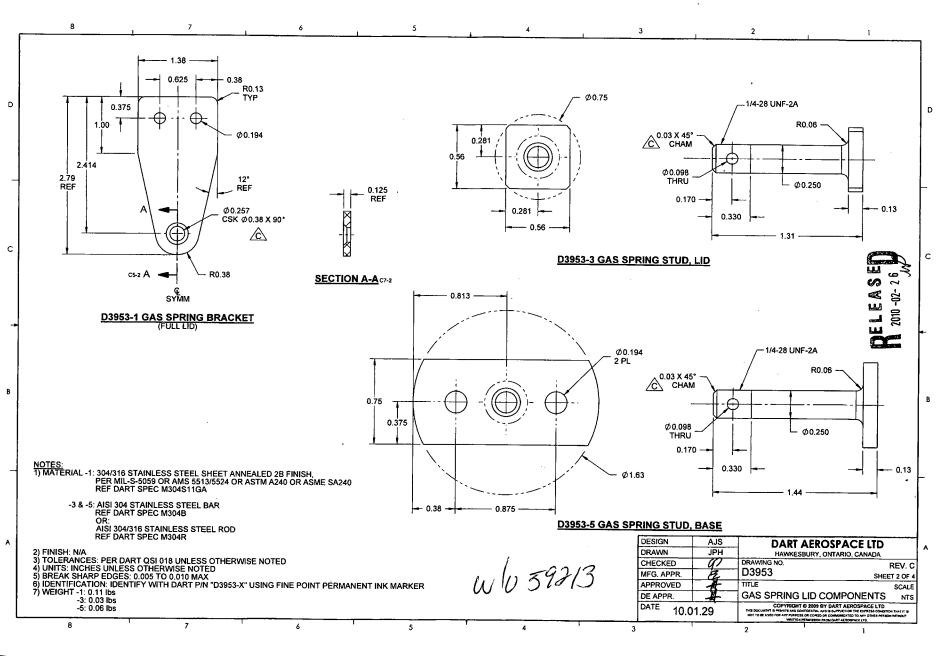
D3953-21 GAS SPRING BRACKET (SQUARE BASKET)



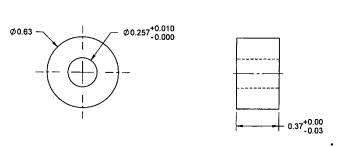
PARTS -19 & -21 ADDED (SHT 18 4): CSK CALLOUT WAS CHAM (C6-2, 86-3, C6-4); © SYMM WAS © SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REOD; DRAFTING ERRORS 10.01.29 SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13 MULTIPLE DIMENSIONS MINMAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY. AJS 09.11.11 NEW ISSUE AJS 09.07.27 REV. DESCRIPTION BY DATE DESIGN AJS

	7.00	DAKI AEKOSPACE LID					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED	a	DRAWING NO.	EV. C				
MFG. APPR.	E	□ D3023	1 OF 4				
APPROVED	4.	TITLE	SCALE				
DE APPR.	#	GAS SPRING LID COMPONENTS	NTS				
DATE 10.0	1.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND COMPORTING AND IS SUPPLIED ON THE EXPRESS CONSTITUTION NOT TO BE USED FOR MY PURPOSE OF COPED ON COMMINENCATED TO ANY OTHER PERSON YEARS	PHAT IT IS				

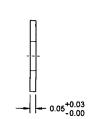
	-												
W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	:	PAR #:	Fault Cated	iorv:	NCB:	Yes N	lo DO	Δ-	Date:				
				Disposition: QA: N/C Closed:									
NCR:				R NON-CONFORM									
DATE	STEP	Description of NC	Corrective Action Section B			· · ·	Verific	cation Approval	Approval	Approval			
	Section A		Initial Chief Eng	Action Description Chief Eng	tion Sign & Date		Section C		Chief Eng	QC Inspector			
						•							
								:					



W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					NCR: Yes No DQA: Date: _							
	Re	solution:	Dispositi	on:	QA:	N/C CI	osed:		Date: _			
NCR:			WORK ORI	DER NON-CONFORM	IANCE	(NCR)					
DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval	Approval		
	STEP Section A	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector		
									4,			
(

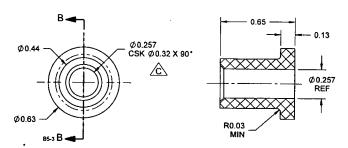


Ø0.63 Ø0.257^{+0.010}

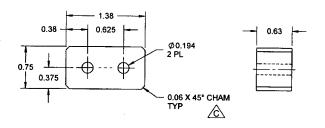


D

D3953-7 GAS SPRING SPACER



D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B 87-3

D3953-13 GAS SPRING SPACER

NOTES: 1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B

- 2) FINISH: N/A 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

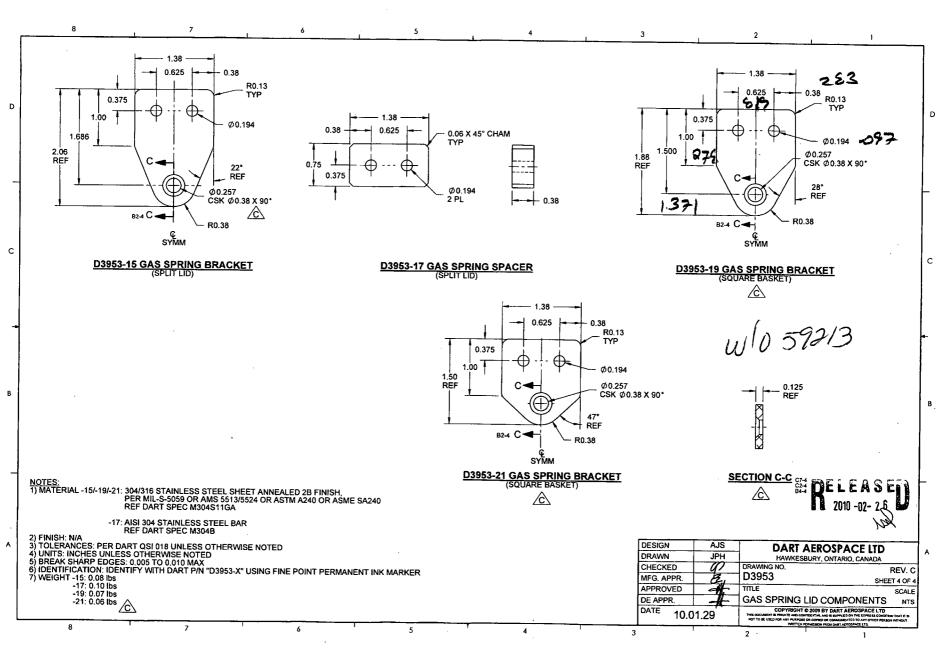
- 5) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
 -13: 0.17 lbs

W/059213

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED (7)		DRAWING NO. R	EV. C				
MFG. APPR.	3	¬ n3053	3 OF 4				
APPROVED	1		SCALE				
DE APPR.	#	GAS SPRING LID COMPONENTS	NTS				
DATE 10.0	1.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS INVALID COMPIDIATION OF DISPLACE ON THIS EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PARFORE OR COPIED OR COMMUNICATED TO ANY OTHER PRISON WITHOUT WRITTEN PERMISSION FROM DATA PROSPORE TO					

D

W/O:	· · · · · · · · · · · · · · · · · · ·	WORK ORDER CHANGES										
DATE	STEP	PR	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		·		•								
								,				
Part No:		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	A:	Date:			
				Disposition: QA: N/C Closed:					Date:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (VCR)			·			
DATE	STEP	Description of NC		ction B	Veritic			Approval	Approval			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector		
									!			
						- <u>-</u>	-		,			
-												



W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			-										
								;					
		•	•										
								Ì					
Part No:		PAR #:	Fault Cate	_ Fault Category: N				A:	_ Date: _				
					QA: N/C Closed: Date:								
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR)	·						
DATE	0	Description of NC	Corrective Action Section B				Verification		Anneoval	Approval			
DATE	STEP Description of NC Section A	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Approval Chief Eng	QC Inspector			
								!					
				, ·									
					,								
				-									
					:								